

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014053**Date Inspected:** 17-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-5

This QA Inspector observed that no significant work was being performed on above mentioned Bay at the time when this QA was present.

BAY-6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005751.

Visual Testing (VT)

This QA Inspector Randomly performed VT of of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. The members are identified as OBG Crossbeam Hand Railing (miscellaneous items) weld Components. Total number of Components Tested: 100 No's.
Refer attached photo for reference.

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This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of West Jacking Frame weld joint WJF-0-187. Welder is identified as 057795. ZPMC Quality Control (QC) is identified as Mr. Zhao jian hang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U4c.

SMAW of West Jacking Frame weld joint WJF-0-200. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Zhao jian hang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U4c.

BAY-7

Flux Cored Arc Welding (FCAW) of weld joint DP3116-001-027/028. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

This QA Inspector observed American Bridge/Fluor (AB/F) QA Inspector was performing Magnetic Particle Testing (MT) for the Deck Panel weld joint No: DP3116-001-030 at Crack Tack weld removed area. Refer attached photos for reference.

FCAW buttering welding of Traveler Rail 22TR3-004. Welder is identified as 222396. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair-1. The buttering was been performed as per the Critical Welding Report (CWR) No: B-CWR1374.

BAY-8

FCAW of weld joint BK004A4-056-043. Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu Chuan Qang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-TC-U4c-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
